

Work Order ID 47774

June 26, 2009 12:27:59 PM



Page 1

Item ID: D3690-041
Revision ID: B
Item Name: Glareshield Assembly

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 1.00
Required Date: 03/08/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference: RETURN

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3690	Rev B

100 Pick Kit

0.00

PPD 50118

PC9/8/18 (1)



Packaging

Memo

0.00

Packaging

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- transfer drill D3697-041 and D3698-1 in D3690-1 and assemble as per dwg
D36901 2- scribe bath # and part # as per dwg

✓

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Paul
Haw

✓

Work Order ID 47774

June 26, 2009 12:27:59 PM

Page 2

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Accept

Setup Start

Stop

Start Date: 15/07/2009 Start Qty: 1.00

Required Date: 03/08/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1- Mask hatched areas (6 pls) on inside of the part prior to painting as per dwg;
2- Paint D3690-041 assy flat black using Basf Glasurit 22 Line code SFA39.50 per Dart QSI 005 4.2

⇒ ml 09 08 17 ①

140

0.00



QC

QC14- Inspect Spray Paint

Memo

0.00

Quality Control

3T 09-08-18

→ IDENTIFY 9 STOCK - SEE ATTACHED W/O

160

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

09/09/04

MF 09-08-24

June 26, 2009 12:27:58 PM

Comments:

Required Qty: 1.00

[illegible]

Date: Thursday, 07/05/2009 8:27:49 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D3690-041
Job Number	: 47774		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D3690041
This Issue	: 07/05/2009	S.O. No. :	Drawing Number : R09-029/NCR09-025
Prsht Rev.	: NC	Project Number	:
First Issue	: / /	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: <u>090507</u>	Due Date	: 14/05/2009
Checked & Approved By	: <u>MF 09-05-07</u>	Qty:	1 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D412776011	Replacement Glareshield
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Replacement Glareshield

The D3690-041 B41937 was only returned from the D412-776-011 B41187 kit. Customer kept the original kit, and was only sent the D3690-041 for replacement.

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Pick the following for re-assembly:

3.0	✓ D36981	Support Angle /
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Support Angle

batch: B41656

FF 09-05-07

4.0	✓ CR3213403	rivet
-----	-------------	-------



Comment: Qty.: 35.0000 Each(s)/Unit Total : 35.0000 Each(s)

Pick the qty of rivets as necessary to install the D3698-1 angle

rivet

batch: M16896 Qty 20

FF 09-05-07

5.0	✓ SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	---------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per attached drawing (Reference only)

FF 09-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/05/2009 8:27:49 AM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D3690-041

Job Number: 47774

Part Number: D3690041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- scribe bath # and part # as per dwg

6.0

✓ QC5

INSPECT WORK TO CURRENT STEP



090507 (1)



Comment: INSPECT WORK TO CURRENT STEP

7.0

✓

SPRAY PAINTING

SPRAY PAINTING



Comment: 1- Mask hatched areas (6 pls) on inside of the part prior to painting as per dwg

2-Paint D3690-041 assy flat black using Basf Glasurit 22 Line code SFA39.50 per Dart QSI 005 4.2

8.0

✓ QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

ST 09-07-30

9.0

✓

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location:

70 9/8/04 09/08/04

10.0

✓ QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DART

Dart Aerospace Ltd.

1270 ABERDEEN ST.
HAWKESBURY ON, CANADA K6A 1K7

TC APPROVAL # 09-89

TEL 1-613-632-5200

P.O. # **D412-776-011**
DESC **Replacement Glareshield**
LOT **B41187**
E.O.D. **Bell 212/412**

CHG **CHG001**
STC **SH08-40**
STC
STC

MADE IN CANADA

D2729-1

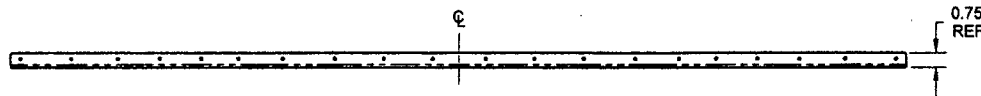
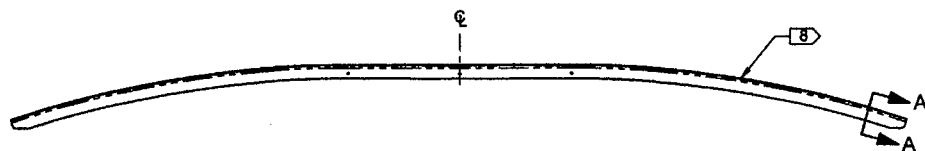
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

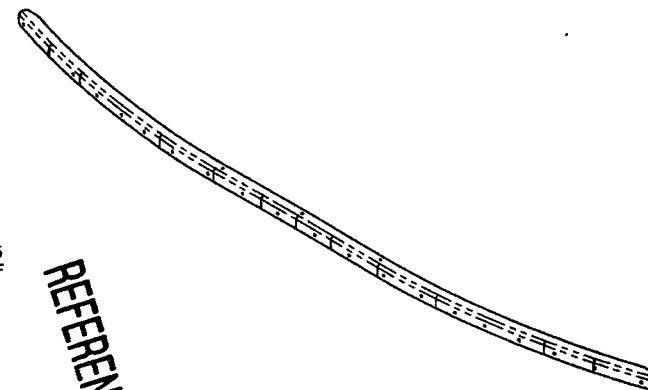
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

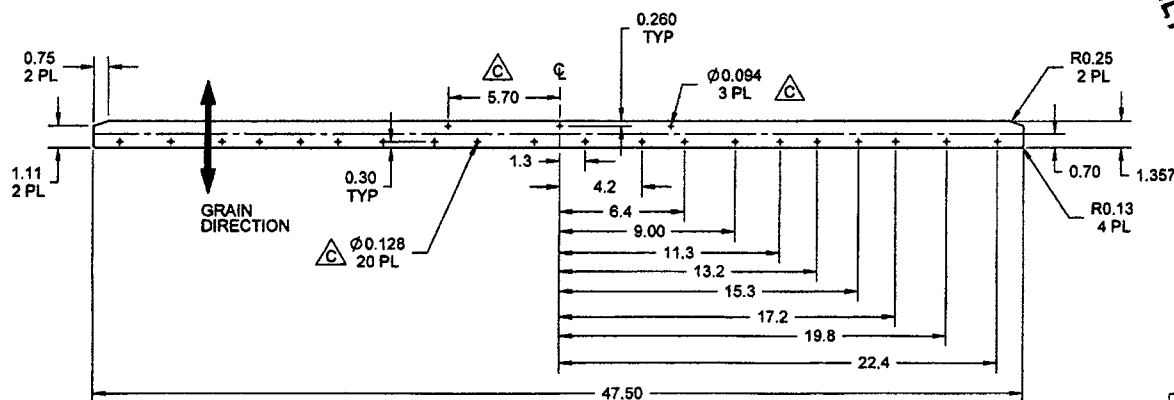
NOTE: Date & initial all entries



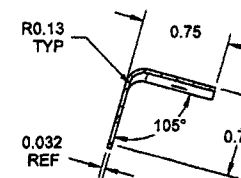
D3698-1 SUPPORT ANGLE
(MAKE FROM D3698-1F FLAT PATTERN)



REFERENCE ONLY



D3698-1F FLAT PATTERN



SECTION A-A

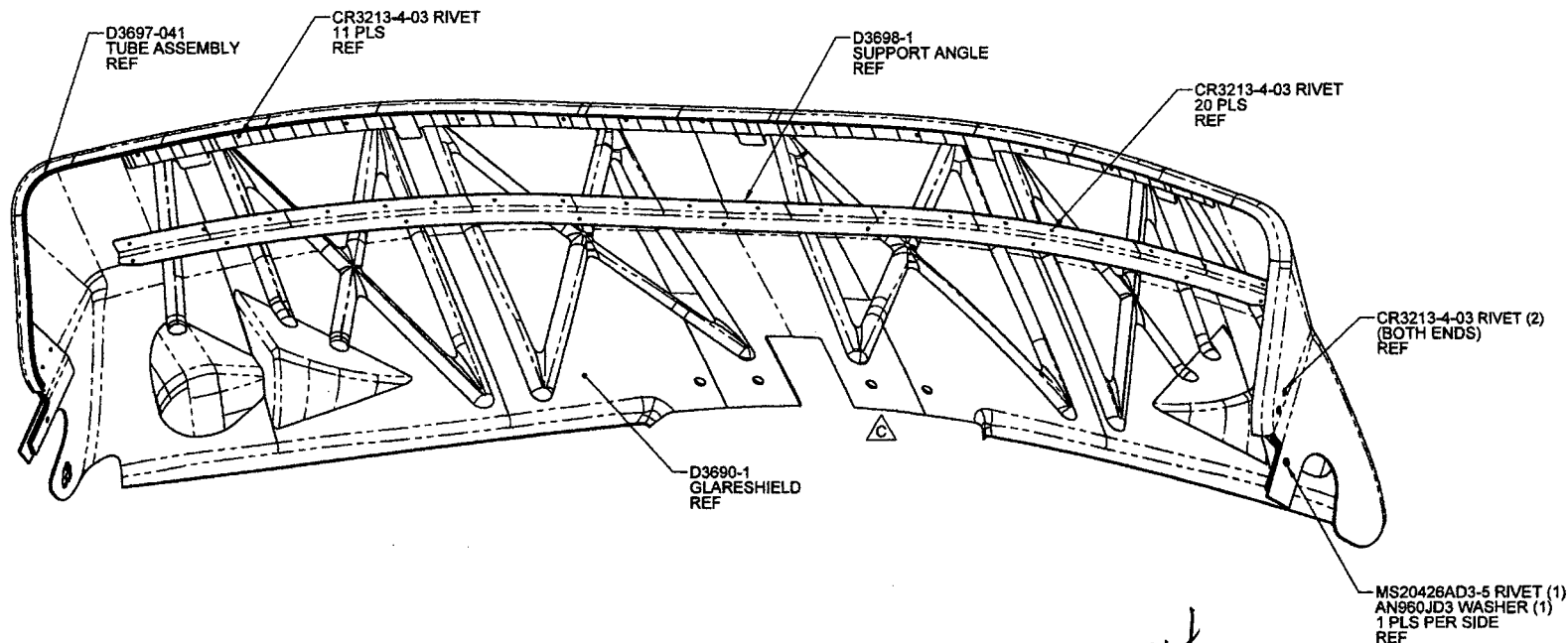
RELEASED
08-29-16

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.032 THICK
REF. DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.20 lbs
- 8) FORM AS PER TEMPLATE DT9001

Handwritten notes:
M6061T6S.032
0.032
0.032

C	ZONE B5 Ø0.094 HOLE QTY WAS 28 PL. ZONE B6 ADDED "Ø0.128, 20 PL". ZONE B6 5.70 DIMENSION WAS REF.	AJS	08.09.08
B	REMOVE POWDER COAT. ZONE A,8	RF	08.06.02
A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3698 REV. C SHEET 1 OF 1 TITLE SUPPORT ANGLE SCALE NTS	
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.08	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3690-041	GLARESHIELD ASSEMBLY
1	D3690-1	GLARESHIELD
1	D3697-041	TUBE ASSEMBLY
1	D3698-1	SUPPORT ANGLE
2	AN960JD3	WASHER (OR NAS1149DN332J)
2	MS20426AD3-5	RIVET
35	CR3213-4-03	RIVET

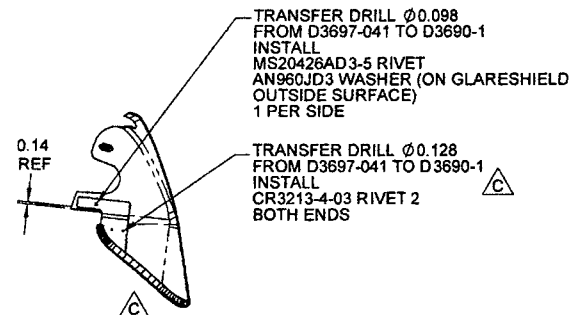
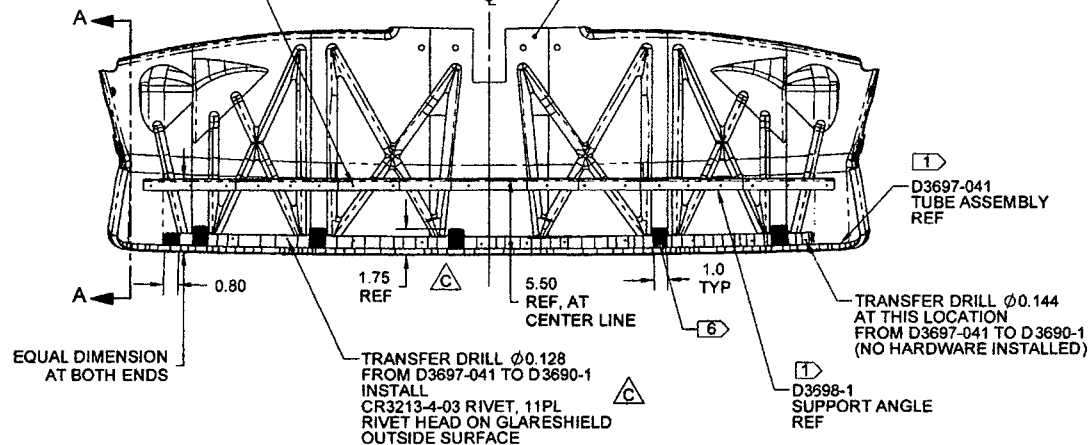
D3690-041 GLARESHIELD ASSEMBLY

REFERENCE ONLY

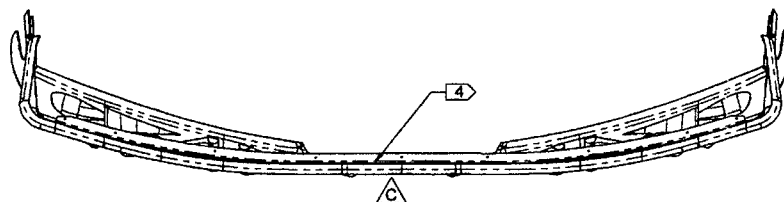
C	SHEET 1 PL MS20426AD3-5 RIVET WAS MS20426AD3-4, CR3213-4-03 RIVET WAS MS20470AD3-4, WASHER QTY WAS 6 (VIEWS UPDATED ACCORDINGLY). RIVETS ON SHEET 1 CHANGED TO REF QTY. RIVETS ON SHEET 2 CHANGED TO "HARD" CALLOUTS. SHADING REMOVED FROM ALL VIEWS FOR CLARITY.	AJS	08.09.02
B	ADD FINISH COAT & 1.0 TYP. SHEET 2 ZONES A, B & C.5; ADD MIN THICKNESS. SHEET 3 ZONE A, B	RF	08.06.24
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	J	DRAWING NO.	REV. C
MFG. APPR.	B	D3690	SHEET 1 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	10	GLARESHIELD ASSEMBLY	NTS
DATE	08.09.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

△ TRANSFER DRILL Ø0.128
FROM D3698-1 TO D3690-1
INSTALL
CR3213-4-03 RIVET, 20 PL
RIVET HEAD ON GLARESHIELD
OUTSIDE SURFACE

D3690-1
GLARESHIELD
REF



SECTION A-A



D3690-041 GLARESHIELD ASSEMBLY

NOTES:

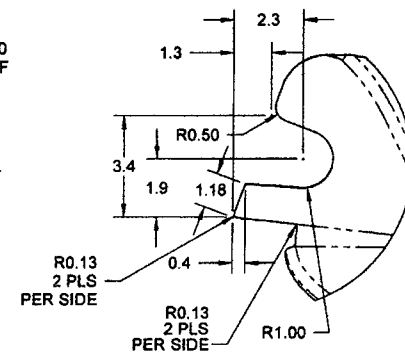
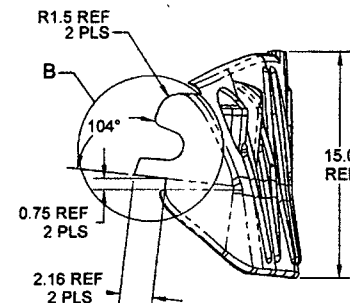
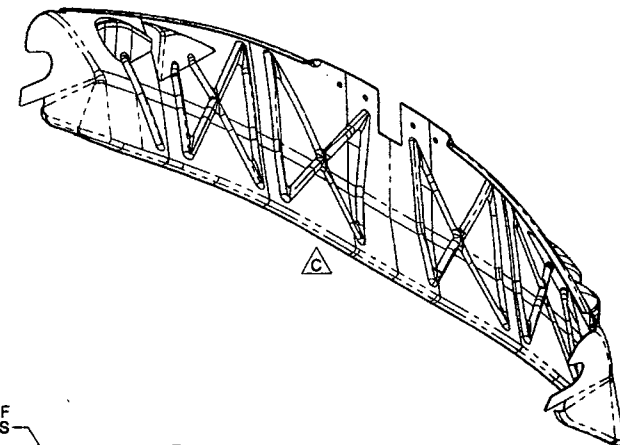
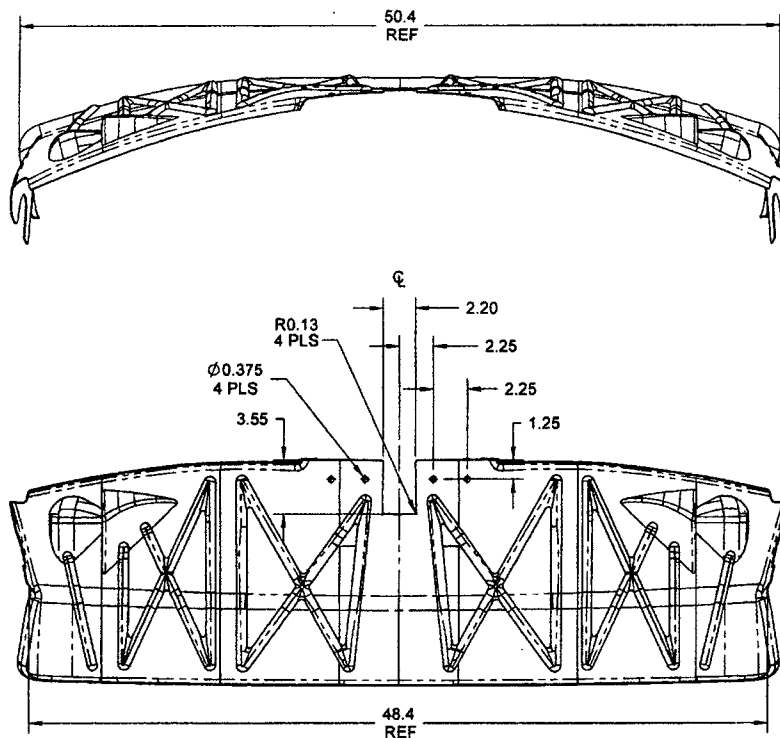
- 1) CENTER D3697-041 AND D3698-1 ON TO D3690-1
- 2) FINISH: PAINT D3690-041 ASSY FLAT BLACK USING BASF GLASURIT 22 LINE CODE SFA39.50 PER DART QSI 018.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: ETCH WITH DART P/N D3690-041 & B/N ON INSIDE OF PART
- 5) WEIGHT: 2.98 lbs
- 6) MASK HATCHED AREAS (6 PLS) ON INSIDE OF THE PART PRIOR TO PAINTING

REFERENCE ONLY

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3690	REV. C
MFG. APPR.	RF	SHEET 2 OF 3	
APPROVED	RF	TITLE GLARESHIELD ASSEMBLY	SCALE NTS
DE APPR.	RF	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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RELEASED
08-09-14

47774



D3690-1 GLARESHIELD

47774





RELEASED
07-07-14

DETAIL B
SCALE 2X
THIS VIEW FOR REFERENCE ONLY

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 2) TOOLING: THERMOFORM PER MOLD DT9010 PER QSI 022
TRIM PER MOLD SCRIBE LINES EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 2.5 lbs
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.040

REFERENCE ON

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3690	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	NTS
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